

Work Order ID 67317

Tuesday, March 15, 2011 10:15:29 AM



Page 1

Item ID: D350-636-105A

Accept



Setup Start



Revision ID:

Stop



Item Name: Wedge Installation

Start Date: 3/15/2011 Start Qty: 8,000

Required Date: 3/21/2011 Req'd Qty: 8,000

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *H*Date: *11-03-15* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9456

A

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D350-636-105A/ DSI9456
CHG001*Sul 11/3/11**9/11/18 BG 11-3-18 (6)*

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

11/3/18 (604)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

*Sul 11/3/11**(46)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67317

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Page 2

Item ID: D350-636-105A

Accept



Setup Start



Revision ID:

Stop



Item Name: Wedge Installation

Start Date: 3/15/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo Identify and pack for shipping as per PPP D3550-636-105A/ DS19456 Location: <u>24</u> PPP rev: <u>A</u>	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

11-03-21
(6)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 15, 2011 10:15:35 AM

Page 1

Work Order ID: 67317

Parent Item: D350-636-105A

Parent Item Name: Wedge Installation



Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3926-1		Manufactured	No			110	Each	22.0000	2	22		11/3/18	
<div> </div>													
Wedge													

Location	Loc Qty	Loc Code
----------	---------	----------

ST149	22	
-------	----	--

53947	14	
-------	----	--

56208	8	
-------	---	--

MS21042L3		Purchased	No			110	Each	2,342.000	4	3224		11/3/18	
<div> </div>													
Nut													

Location	Loc Qty	Loc Code
----------	---------	----------

ST300	2342	
-------	------	--

116391	742	
--------	-----	--

116540	800	
--------	-----	--

116549	800	
--------	-----	--

MS24693-S276		Purchased	No			110	Each	85.0000	4	3224		11/3/18	
<div> </div>													
SCREW													

Location	Loc Qty	Loc Code
----------	---------	----------

ST288	85	
-------	----	--

104374	85	
--------	----	--

NAS1149D0363J		Purchased	No			110	Each	2,318.000	4	3224		11/3/18	
<div> </div>													
Washer													

Location	Loc Qty	Loc Code
----------	---------	----------

ST298	2318	
-------	------	--

116583	2318	
--------	------	--

W/O:		WORK ORDER CHANGES					
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

The D350-636-105A/B Wedge Kits can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105A Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA with the low angle float extensions but is not compatible with OEM skidtubes. The D350-636-105B Wedge Kit is compatible with non-float tube equipped skidtubes but is not compatible with OEM skidtubes.

The D350-636-105A/B Wedge kits are installed as follows:

- 1) Remove the D2741 blades from the D350-636 skidtube assemblies
- 2) Drill 2x $\varnothing 0.201$ (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes $\varnothing 0.385 \times 100^\circ$ from the bottom of each D2741 blade
- 4) Position the D3926-1/-3 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x $\varnothing 0.201$ (#7 drill) from each D2741 blade to the D3926-1/-3 wedge and deburr
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Install the D3926-3 wedge on each D2741 blade using the hardware shown in Figure 3 Sheet 3
- 9) Re-install the D2741 blade onto the D350-636 skidtube assembly in accordance with IIN-D350-636.
- 10) It is acceptable to install blade tape (abrasion strip material) on the float tube extension to prevent wear between the D3926-1 wedge and the float tube extension.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105A Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg
D350-636-105B Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg

PARTS LIST

QTY. -105A	QTY. -105B	PART NUMBER	DESCRIPTION
X		D350-636-105A	Wedge Kit
	X	D350-636-105B	Wedge Kit
2		D3926-1	WEDGE
	2	D3926-3	WEDGE
4	4	MS21042L3	NUT
4	4	MS24693S276	SCREW
4	4	NAS1149D0363J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67317

2111-03-15

A	NEW ISSUE	<i>JS</i>	09.07.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9456	SHEET 1 OF 3
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	WEDGE KIT	NTS
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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

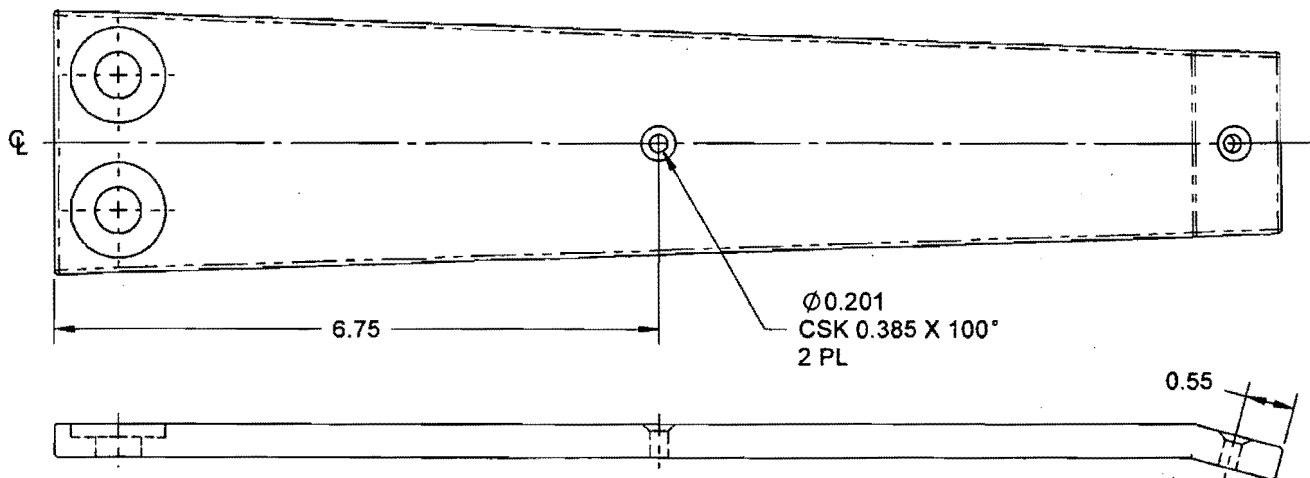


FIGURE 1: D2741 BLADE DRILLING DETAIL

W/O 67317

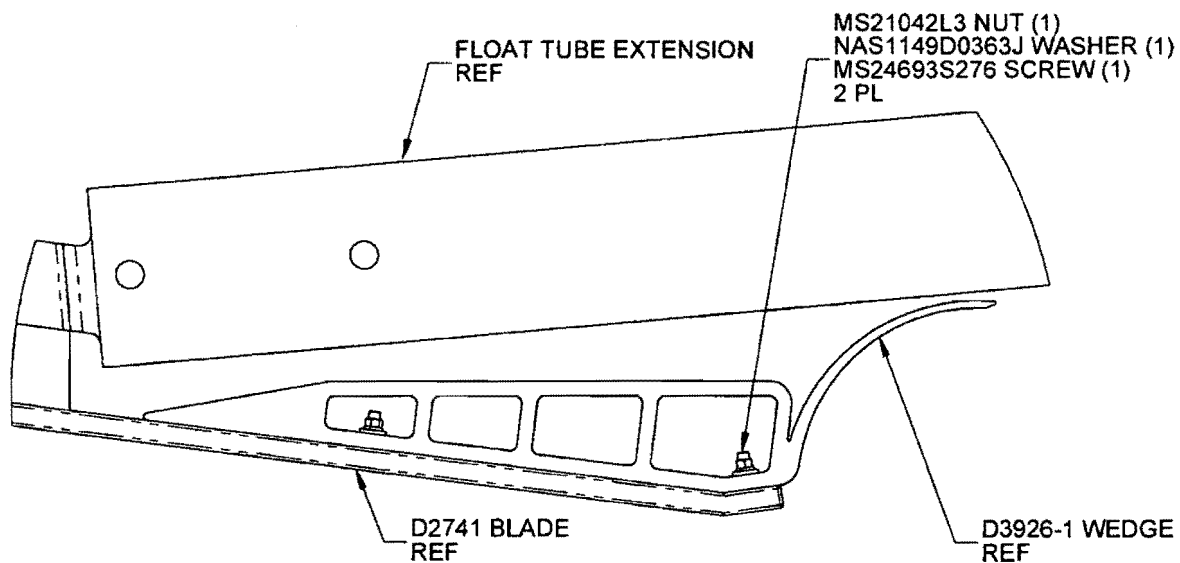


FIGURE 2: D3926-1 WEDGE INSTALLATION

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9456	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEDGE KIT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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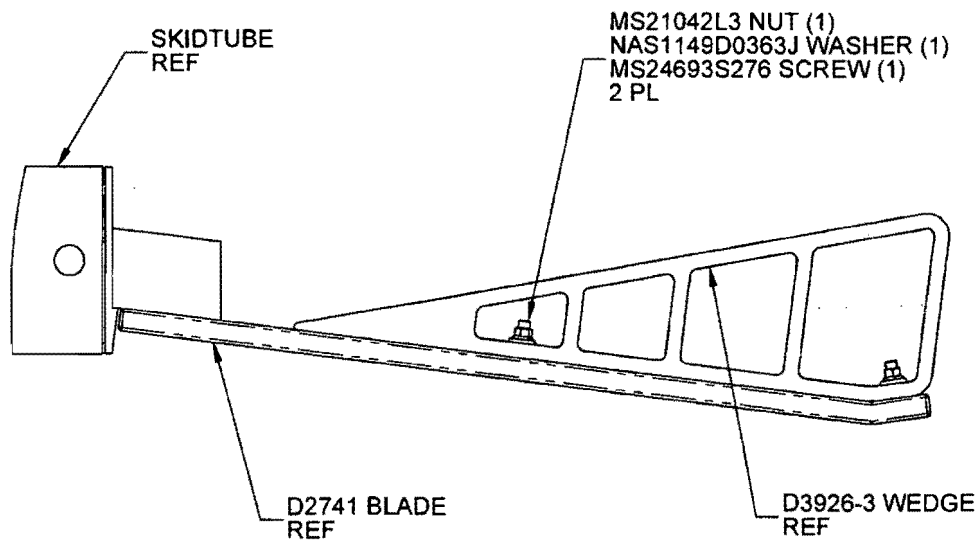


FIGURE 3: D3926-3 WEDGE INSTALLATION

w/o 67317

DESIGN	<i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AS</i>		
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9456	SHEET 3 OF 3
APPROVED	<i>149</i>	TITLE	SCALE
DE APPR.	<i>149</i>	WEDGE KIT	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D350-636

Page 28 of 31

7.0 PARTS LIST

(D350-636-101/-103/-104/-105A/-105B/-107/-107A/-107B/-109 KITS)

Item	Qty -101	Qty -103	Qty -104	Qty -105A	Qty -105B	Qty -107	Qty -107A	Qty -107B	Qty -109	Part Number	Description
	X			()						D350-636-101	TOE STEP KIT (LH/RH)
		X		U						D350-636-103	APICAL FLOAT CONVERSION KIT, LH
			X							D350-636-104	APICAL FLOAT CONVERSION KIT, RH
				X						D350-636-105A	WEDGE KIT
					X					D350-636-105B	WEDGE KIT
						X				D350-636-107	CABLE GUARD KIT
						1	X			D350-636-107A	FWD CABLE GUARD
						1		X		D350-636-107B	AFT CABLE GUARD
									X	D350-636-109	TOW RING KIT
8		1								D3488-041	BLADE FITTING, LH (REPLACES D2742-1)
8			1							D3488-042	BLADE FITTING, RH (REPLACES D2742-2)
10		2	2							AN8C21A	BOLT (REPLACES AN8-16A)
11		2	2							AN960JD816	WASHER (OR NAS1149D0863J)
12		2	2							MS21083C8	NUT (REPLACES MS21083N8)
26B		4	4							AN3C7A	BOLT (REPLACES AN3-7A)
27		4	4							AN960C10L	WASHER (REPLACES AN960JD10)
40	1									D3487-1	TOE STEP ASSEMBLY
43		2	2							D3493-1	WASHER
50		2	2							D3532-1	WASHER
60				2						D3926-1	WEDGE
61				2						D3926-3	WEDGE
62				4	4					MS21042L3	NUT
63				4	4					MS24693S276	SCREW
64				4	4					NAS1149D0363J	WASHER
70							1			D3927-1	FWD CABLE GUARD
71								1		D3927-3	AFT CABLE GUARD
72							2			D3928-1	BRACKET
73							2			AN4-14A	BOLT
74								1		BLBS-020	PIP PIN
75							2			MS21042L4	NUT
76							4			NAS1149D0463J	WASHER
80									1	D3407-043	TOW RING ASSEMBLY
81									2	D3417-9	WASHER
82									1	D3456-1	WASHER
83									1	MS21043-4	NUT

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Revision: H
Date: 10.07.26